

Date: Monday, 11/21/2005 7:43:14 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 24928		
Estimate Number	: 10698	Part Number	: D34631
P.O. Number	: N/A	Drawing Number	: D3463
This Issue	: 11/21/2005 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: N/A Type : SMALL /MED FAB	Material	: N/A
Previous Run	: N/A	Due Date	: 11/28/2005 Qty: 2 Um: Each
Written By	: <u>See comment below</u>		
Checked & Approved By	: <u>See comment below</u>		
Comment	: EST REV. A 05.11.17 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M316TR100W120

Inventory



Comment: Qty.: 2.1872 f(s)/Unit Total: 4.3743 f(s)
AISI 316 SS seamless tubing 1.00" OD X 0.120 wall
(M316TR1.00w120)
Batch: M18457

2.0

BAND SAW

BAND SAW



Comment: BAND SAW
Cut blank 25.00 " long

SB 05/11/23

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Bend as per dwg D3463

2-Trim to lenght per dwg D3463

3- Deburr

SB 05/11/23

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

EC 05.11.23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 05/12/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description:

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
1- Drill as per dwg D3463

2-Deburr as per dwg D3463

EC 05.11.30

1

6.0

~~QC~~ QCS

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

05.11.30

1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

N/A

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A*

EC 05.11.30

1

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SUR 05/12/01

05/12/01

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

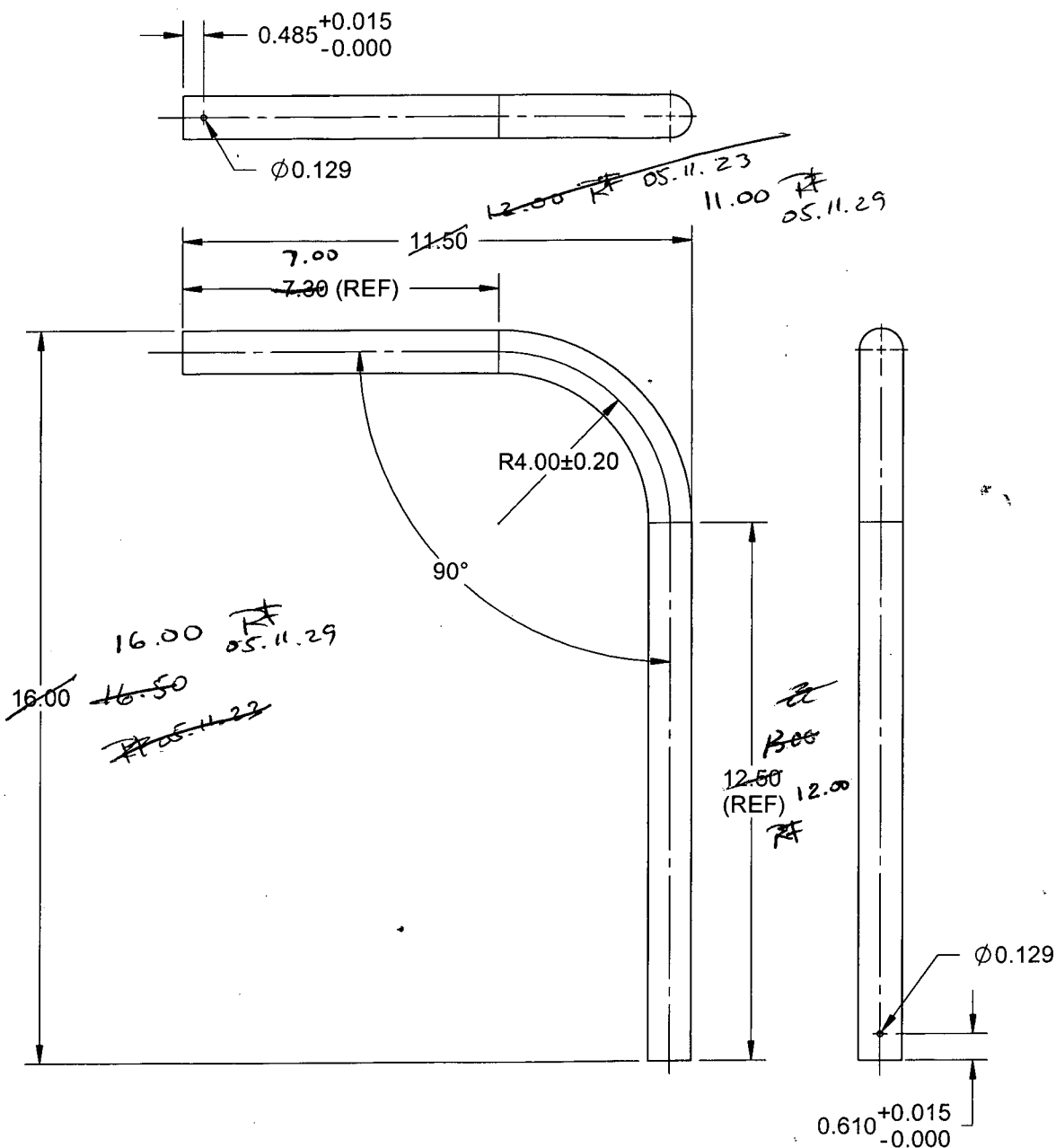
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3463	REV. A SHEET 2 OF 4
DATE 05.09.20		TITLE STEP WELDMENT	SCALE 1:4



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS 1.00 x 0.120 WALL ROUND TUBING
(REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKER SHARP EDGES 0.005 TO 0.025

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